

Date: Monday, 18/08/2008 3:45:38 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLADE POSITIONER WELDMENT
Job Number :	41376		
Estimate Number :	13443		
P.O. Number :		Part Number :	PB674300129
This Issue :	18/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.40
First Issue :	/ /	Project Number :	N/A
Previous Run :	40241	Drawing Revision :	B1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	18/09/2008
Written By :		Qty:	18 2 Um: Each
Checked & Approved By :	JD 08.8.18		
Comment :	Est Rev:A 08-06-27 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001313	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Plate
 batch: B41503

JD 08-10-04 2

2.0	PB6743001319	Gusset
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Gusset
 batch: B41504

JD 08-10-04 2

3.0	PB6743001337	Upper Pad Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Upper Pad Assembly
 batch: B41506

JD 08-10-04 2

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1,
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Comment: LARGE FABRICATION RESOURCE 1
 ****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF
 VERTICAL, PRIOR TO WELDING****
 1- ASSEMBLE AND WELD AS PER DWG

JD 08-10-04 2

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

JD 08-10-09/PS 08-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER WELDMENT

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/09 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

M/S 08/10/09

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
320 °C
2:30

M/S 08/10/09

(2X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/10/09 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SE510 121

SS 08/10/10 x2

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/10

Job Completion



mf 08-10-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

